

Date: Friday, 7/6/2007 1:29:01 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP (CASTING DETAIL)
Job Number : 33320	
Estimate Number : 11088	
P.O. Number : N/A	Part Number : D25761
This Issue : 7/6/2007	Drawing Number : D2576 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : F
Previous Run : 31940	Material : N/A
Written By :	Due Date : 7/20/2007
Checked & Approved By :	Qty: 100 Um: Each
Comment : Est Rev: A New Issue 05-11-29 JLM est rev B rev F dwg 07.07.06 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 4116

Ship D2576 mould to vendor

Cast per D2576-1 Pattern

Material Release Note Required

CLO 7/07/06

(100)

2.0	D25761P	Step (Casting Detail)
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

STEP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure D2576 mould is returned with the ordered parts

Ensure release note is attached

PU 7/7/19

(100)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECKcounted
EP 07/07/12

(x100)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Barcode

PU 7/7/15 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 21/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 33320

Part Number: D25761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.29
AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.07.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

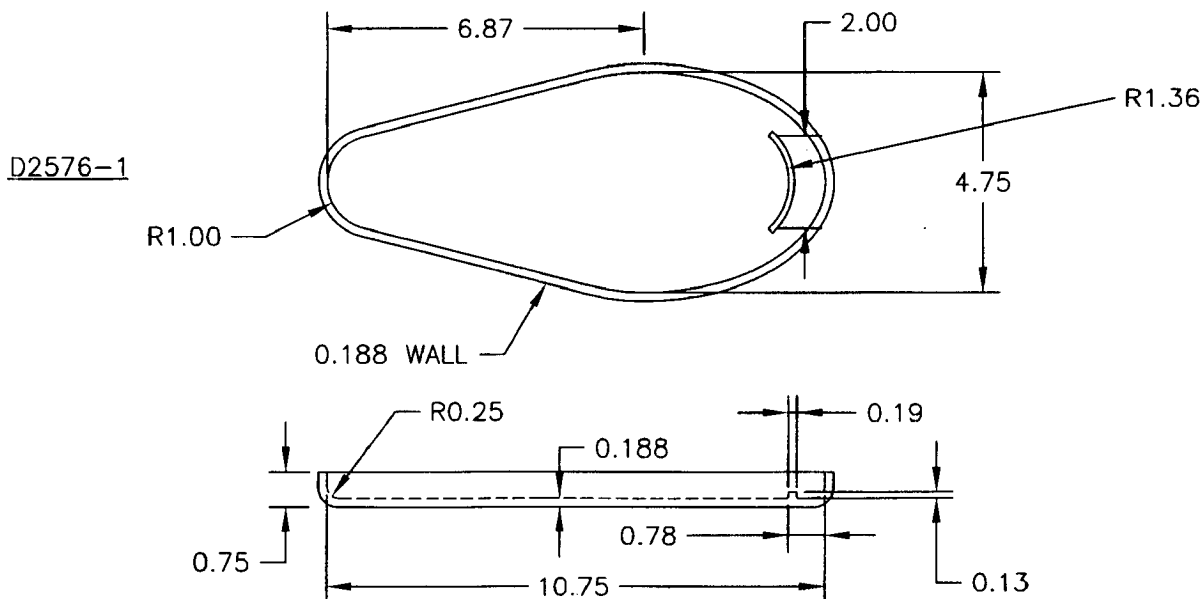


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2576	REV. F SHEET 1 OF 1
DATE 07.04.17		TITLE STEP	SCALE 1:4
A	96.09.18	NEW ISSUE	
B	96.11.28	REMOVE POCKETS, ADD HOLE	
C	98.08.18	ADD POCKETS & SLOTS FOR WELDING	
D	99.08.18	CHNG. SLOT SIZE AND LOC.(TSR A1069)	
E	99.09.07	CHNG. 0.50 HOLE LOC. AND ADD NOTE	
F	07.04.17	7.05 WAS 6.61	

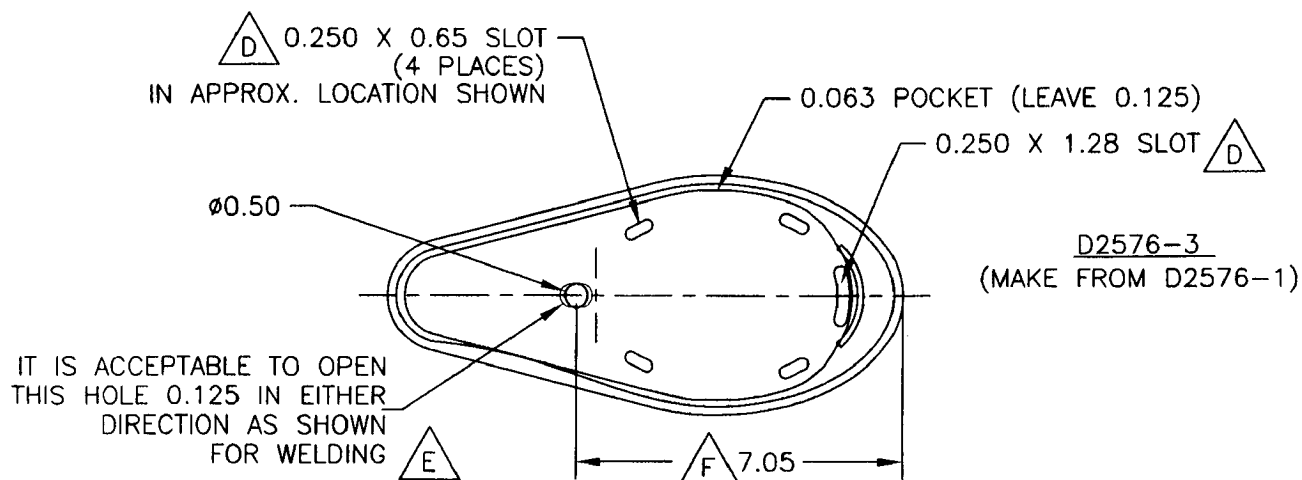
RELEASED
07.06.18

D2576-1 CASTING DETAIL

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.025 TO 0.050



D2576-3 MACHINING DETAIL



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w/o 33320
C207/07/06

ALPINE NON-FERROUS FOUNDRY8657-132ND STREET
SURREY, B.C. V3W 4P1**WORK ORDER**

Tel: (604) 596-8080

Fax: (604) 596-8045

Sold To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ONT K6A 1K7
CANADA**Ship To: DART AEROSPACE**

Order Date		Purchase Order#	Due Date	Ship Via			Page
06-Jul-2007		PO0004116 <i>sh</i>	23-Jul-2007	FEDEX			1
Item#	Item Code	Description	Material	Ordered	E/O	Qty Ship	
1	DART D2576	D2576 STEP CSTG		100		104	
2							

Comments

Castings & Patterns are property of Alpine until paid in full

July 17/07

CERTIFICATE OF ANALYSIS

CUSTOM ALLOY LIGHT METALS
13329 ECTOR STREET CITY OF INDUSTRY, CA 91746
PH# (626) 369-3641 FAX# (626) 369-2471

CUSTOMER:

RYPAC ALUMINUM
11849 TANNERY ROAD
SURREY BRITISH COLUMBIA,

SHIP DATE

MAR 16 2007

CONFORMS TO ASTM SPECIFICATION: B179-03

Alloy: 535.2

Heat: G920

Si	0.054
Fe	0.071
Cu	0.001
Mn	0.152
Mg	7.060
Cr	0.001
Zn	0.004
Ti	0.171
Sn	0.003
Pb	0.001
Ni	0.001
OET	< .15
Sr	0.000
Al	REMAINDER

Si	.10
Fe	.10
Cu	.05
Mn	.10-25
Mg	6.6-7.5
Cr	
Zn	.05
Ti	.10-25
Sn	
Pb	
Ni	
OET	.15
Sr	
Al	REMAINDER

BE .004

BE .003-.007

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST OR ARE TRACEABLE TO NIST.

Ron Zakrzewski

MAR 16 2007

RON ZAKRZEWSKI

DATE

LAB MANAGER

PM-12.01 Rev D 12/5/2001

WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CREVICES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.